



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-636-0
Job Sheet 18422



Part No: D350-636-011

Job Qty: 1 ea

Part Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/3/18

Job Tracking No:

Due Date: 10/9/18

Created By: Jesse White

Type: SOLD

Description:

Note: D2750-041 REV G SHEETS 1,2,4,8 IPP Rev:I 02.09.25 IPP Rev:J 06-03-23 As per Rev D IPP Rev:K 06-07.13
As per dsi9343 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC IPP Rev:M 08-04-22 DD
verified:EC IPP Rev:N 08-09-23 revF DD verified:ec IPP Rev:O 09-02-06 per PAR09-010 DD verf:EC IPP
Rev:P 10.06.22 revise seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH DDverf:EC IPP REV:R
13.08.27 PER ECN13-594 DD VERF:JLM

Ship Via:

Cont: 15836



Part: D350-636-011

Job No: 184225

Serial No. Batch: S115836

Revision:

Inspector:

Exp Date:

Instructions: TC STD SH99-7 Issue 2, FAA STD SR00646SE 15/10/28, EASA STC

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		10/9/18	0.00	0.00	Start Up Skidtubes-1		
110	Skidtubes	1 pcs		10/9/18	0.00	4.55	Skidtubes-4		
120	QC	1 pcs		10/9/18	0.00	0.00	QC10		
130	QC	1 pcs		10/9/18	0.00	0.00	QC5		
140	HandFinish	1 pcs		10/9/18	0.00	0.93	HandFinish1		
150	QC	1 pcs		10/9/18	0.00	0.00	QC7-2		
160	Skidtubes	1 pcs		10/9/18	0.00	4.55	Skidtubes-4		
170	QC	1 pcs		10/9/18	0.00	0.00	QC10		
180	QC	1 pcs		10/9/18	0.00	0.00	QC5		
190	HandFinish	1 pcs		10/9/18	0.00	0.93	HandFinish2		
200	SprayPaint	1 pcs		10/9/18	0.00	0.91	Spray Paint		
205	Outsource	1 pcs		10/9/18			ATE003-VC		
210	QC	1 pcs		10/9/18	0.00	0.00	QC14		
230	HandFinish	1 pcs		10/9/18	0.00	0.93	HandFinish4		
240	QC	1 pcs		10/9/18	0.00	0.00	QC5		
250	Packaging	1 pcs		10/9/18	0.00	0.00	Packaging1-3		
260	QC	1 pcs		10/9/18	0.00	0.00	QC4		
270	Packaging	1 pcs		10/9/18	0.00	0.00	Packaging3-1		
275	DC	1 pcs		10/9/18	0.00	0.00	DC		
280	QC21-FG	1 Ea		10/9/18	0.00	0.00	QC21		

Part Op 110 - 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg
 Descriptions: D2750-1 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill
 then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER

POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D2750
 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for 2nd side only DT8863B for first side (detail B) 4-
 Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY
 AND RECORD FWD BEND ANGLE. 5-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 6-
 Open up holes of Detail A to 0.297" (total of 2 holes per side) 7-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill
 grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: 138673 8-Grind welds flush as per Dwg
 D2750

160 - 1-Open up holes using hole saw of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg
 D2750. 2-Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750. 3- Open float
 hole using un-bit to 0.500" (4 per side) 4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
 (welding instructions on sheet 8) 5-Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove
 alodine as required. 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 1138943
 exp. date: 19/03/16 ***ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D3490-1, D3490-3
 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: 9- At
 section AJ-AJ drill out x-bolt spacer to 0.404" 10-Grind welds flush as per Dwg D2750 11-Spot face ground handling holes
 section (total of 4 places per side) as per dwg D2750 12-Deburr holes, ensure tube is free of all scratches before sending
 to paint.

180 - ***VERIFY C'BOARD IS GOOD***

190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 2-
 PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH:

210 - Inspect for foreign object per QSI 024

230 - 1- Install inserts as per Dwg D2750 2-Inspect for Foreign Objects 3- Install blade fitting D3488-041, wearshoes and
 ground handling hardware as per dwg D2750 SIKAFLEX 241 BATCH: EXP DATE: 4-
 Assemble o-ring to plug as per dwg D3492 and apply o-ring lube A/R 55-o-ring lube batch: 5- Coat all
 exposed fasteners with "LPS Procyon" batch:

260 - *****ensure antiseize is on AN8C21A bolts*****

270 - Package as per PPP D350-636-011 Location : FG072

275 - record fwd angle: 89.9 Photocopy blue file and type labels per PPP D350-636-011 CHG 007

205 P004713 - next

Job BOM

007619

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-LH	Extrusion Bent LH	1 Ea (1 ea)	90-Start up Operation	5082073
D2744	Cap	1 Ea (1 ea)	110-Skidtubes	5060499
D2739	350 I-Beam	1 Ea (1 ea)	160-Skidtubes	5102814
D2743	Crossbolt Spacer	8 Ea (8 ea)	160-Skidtubes	5122933
D3490-1	Cross Bolt Spacer	4 Ea (4 ea)	160-Skidtubes	5082748
D3490-3	Cross Bolt Spacer	4 Ea (4 ea)	160-Skidtubes	5107862
AN3C5A	Bolt	34 Ea (34 ea)	230-HandFinish	50952W
AN3C6A	Bolt	4 Ea (4 ea)	230-HandFinish	5049457
AN6C44A	Bolt	4 Ea (4 ea)	230-HandFinish	5066337
AN8C35A	Bolt	1 Ea (1 ea)	230-HandFinish	5090792
D2745	Bushing	8 Ea (8 ea)	230-HandFinish	5122863
D3488-041	Blade Fitting LH	1 Ea (1 ea)	230-HandFinish	X 5128411
D3492-1	Plug	8 Ea (8 ea)	230-HandFinish	5127306
D3492-3	Plug	8 Ea (8 ea)	230-HandFinish	5107038 x7
D3535-25	Wearplate Center	1 Ea (1 ea)	230-HandFinish	5132949
D3536-25	Gasket Center	1 Ea (1 ea)	230-HandFinish	5097706
D3537-1	Wearpad	3 Ea (3 ea)	230-HandFinish	5108681
D3631-1	Washer	8 Ea (8 ea)	230-HandFinish	5058402
D3791-1	Wearpad	1 Ea (1 ea)	230-HandFinish	507706
D3793-1	Wearplate Fwd	1 Ea (1 ea)	230-HandFinish	5127531
D3793-3	Wearplate Aft	1 Ea (1 ea)	230-HandFinish	5127536
D3794-1	Gasket Fwd	1 Ea (1 ea)	230-HandFinish	N/A
D3794-3	Gasket Aft	1 Ea (1 ea)	230-HandFinish	N/A
MS21043-6	Nut	4 Ea (4 ea)	230-HandFinish	5058146
MS21083C8	Nut	1 Ea (1 ea)	230-HandFinish	5090632
NAS1149C0332R	Washer	38 Ea (38 ea)	230-HandFinish	5130139
NAS1149C0832R	Washer	1 Ea (1 ea)	230-HandFinish	5076017-2
NAS1515H3L	Washer	4 Ea (4 ea)	230-HandFinish	5083359
NAS1611-010	O-Ring	8 Ea (8 ea)	230-HandFinish	5106792
NAS1611-013	O-Ring	8 Ea (8 ea)	230-HandFinish	5057659
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-HandFinish	5058132
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging	5079136
D2741	Replacement Blade	1 Ea (1 ea)	250-Packaging	508228
D3493-1	Washer	2 Ea (2 ea)	250-Packaging	5125813
D3532-1	Spacer	2 Ea (2 ea)	250-Packaging	5090421
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging	5104646
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging	5089248

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-3-BENT-LH	1	16	0
	D2744	1	38	0
	D2739	1	13	0
	D2743	8	15	0
110-Skidtubes	D3490-1	4	71	0
	D3490-3	4	94	0
	ALS4-1032-225	38	1,848	0
	AN3C5A	34	1,850	0
160-Skidtubes	AN3C6A	4	222	0
	AN6C44A	4	142	0
	AN8C35A	1	45	0
	D2745	8	91	0
	D3488-041	1	6	0
	D3492-1	8	108	0
	D3492-3	8	153	0
	D3535-25	1	21	0
	D3536-25	1	34	0
	D3537-1	3	277	0
	D3631-1	8	515	0
	D3791-1	1	26	0
	D3793-1	1	21	0
	D3793-3	1	21	0
	D3794-1	1	24	0
	D3794-3	1	21	0
	MS21043-6	4	185	0
	MS21083C8	1	175	0
	NAS1149C0332R	38	4,327	0
	NAS1149C0832R	1	400	0
	NAS1515H3L	4	455	0
	NAS1611-010	8	703	0
	NAS1611-013	8	305	0
230-HandFinish	AN8C21A	2	99	0
	D2741	1	64	0
	D3493-1	2	13	0
	D3532-1	2	36	0
	MS21083C8	2	175	0
	NAS1149D0863J	2	99	0
250-Packaging				

Part Specifications

Specifications could not be found.

Plex 10/3/18 3:13 PM dart.white.jesse

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

RELEASED
2013-08-13
WP

G	CORRECTED TOLERANCE ON Ø0.500 THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/S-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PART13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D2750 TITLE 350 SKIDTUBE ASSEMBLY NTS COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
DRAWN	MM		
CHECKED	MM		
MFG. APPR.	MM		
APPROVED	MM		
DE APPR.	MM	REV. G SHEET 1 OF 11 SCALE NTS	
DATE	13.07.11		

8 7 6 5 4 3 2 1

D

D

C

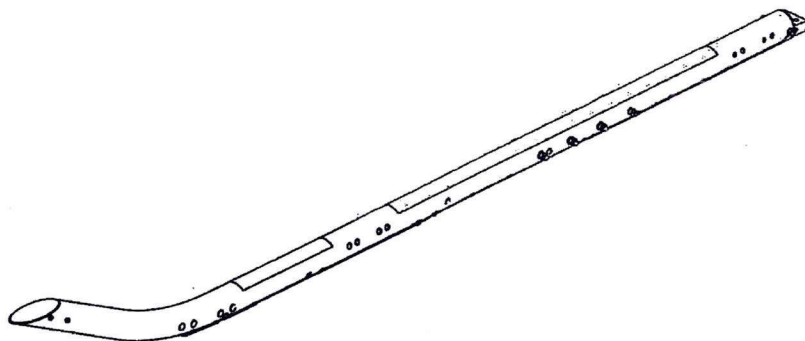
C

B

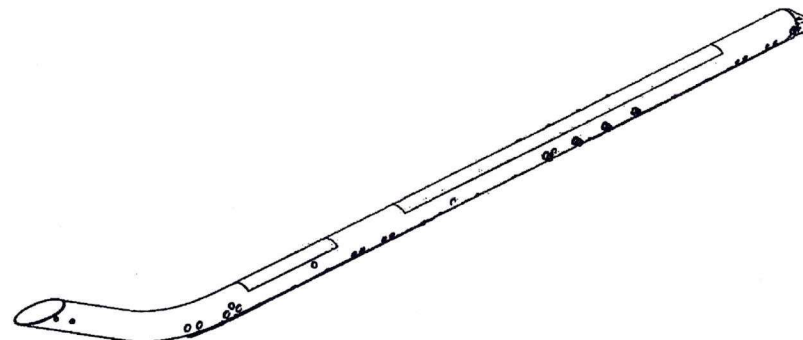
B

A

A



D2750-041 350 SKIDTUBE ASSEMBLY, LH

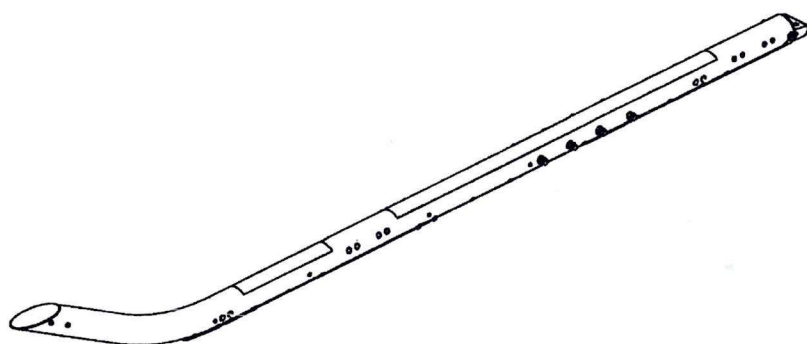


D2750-042 350 SKIDTUBE ASSEMBLY, RH

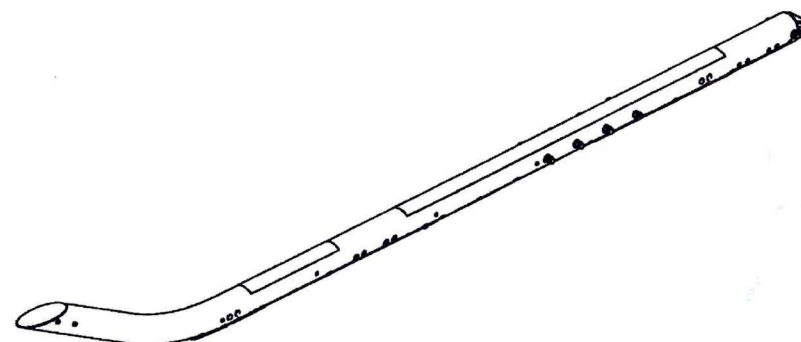
RELEASED
2013-08-13
MD

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	<i>[Signature]</i>	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D2750	REV. G
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 11	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1999 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1



D2750-043 350 SKIDTUBE ASSEMBLY, LH

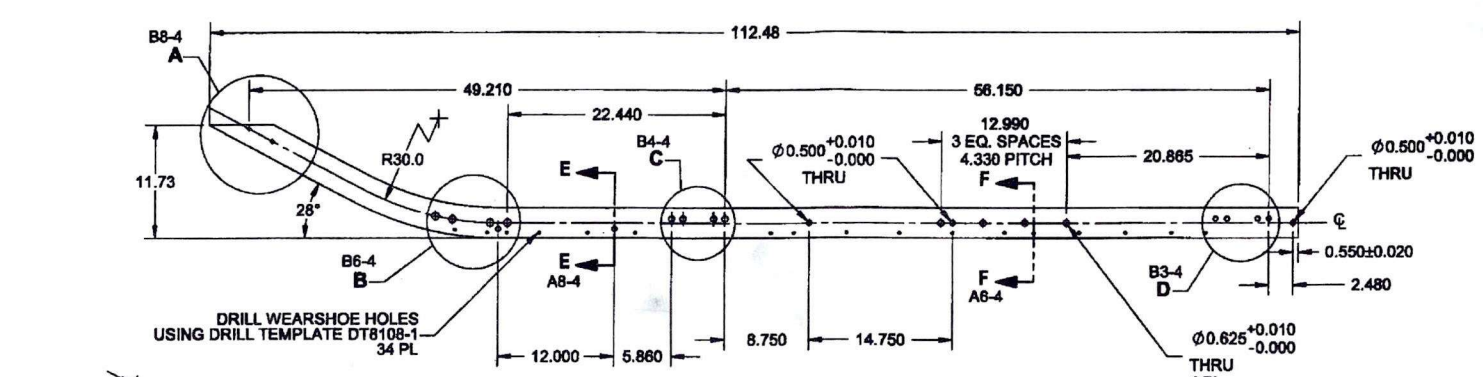


D2750-044 350 SKIDTUBE ASSEMBLY, RH

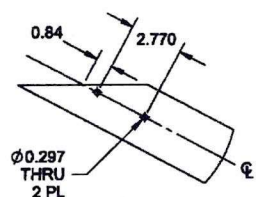
RELEASED
2013-08-13
mp

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D2750	REV. G
MFG. APPR.		TITLE	SHEET 3 OF 11
APPROVED	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	SCALE
DE APPR.			NTS
DATE	13.07.11	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

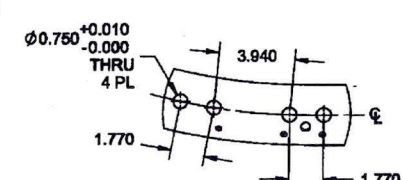
8 7 6 5 4 3 2 1



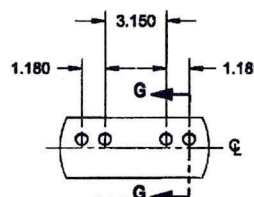
D2750-1 LH SKIDTUBE



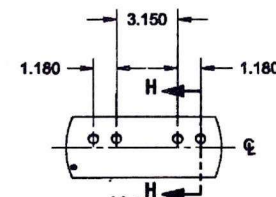
DETAIL A
SCALE 2X



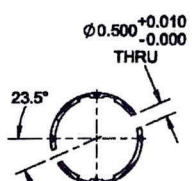
DETAIL B
SCALE 2X



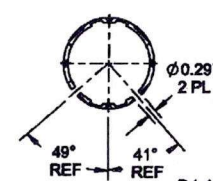
DETAIL C
SCALE 2X



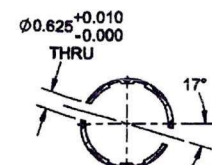
DETAIL D
SCALE 2X



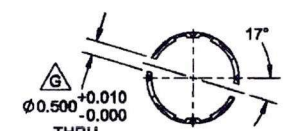
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



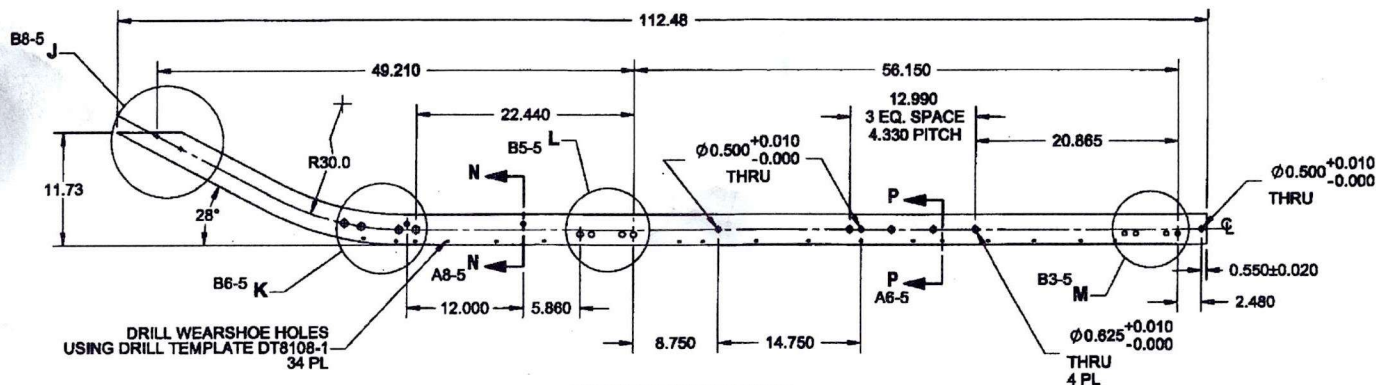
SECTION H-H
SCALE 3X, 4 PL

RELEASED
2013-08-13

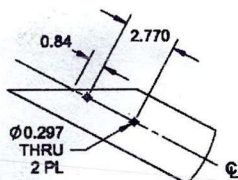
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D2750	REV. G
MFG. APPR.		SHEET 4 OF 11	
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
DE APPR.		COPYRIGHT © 1988 BY DART AEROSPACE USA, INC.	
DATE 13.07.11		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

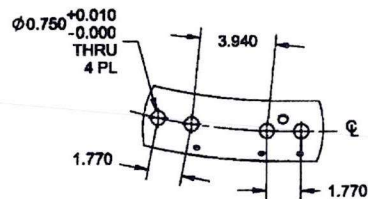
8 7 6 5 4 3 2 1



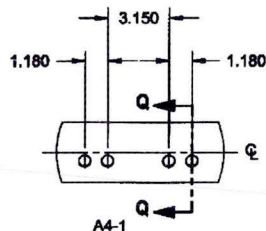
D2750-2 RH SKIDTUBE



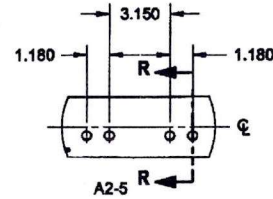
DETAIL J
SCALE 2X



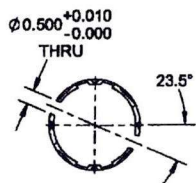
DETAIL K
SCALE 2X



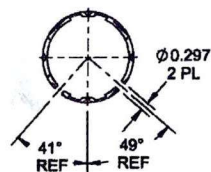
DETAIL L
SCALE 2X



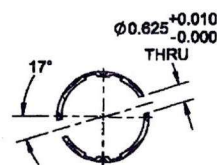
DETAIL M
SCALE 2X



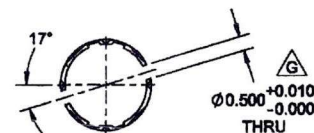
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



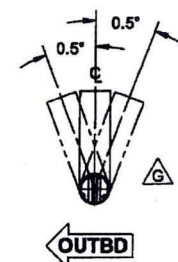
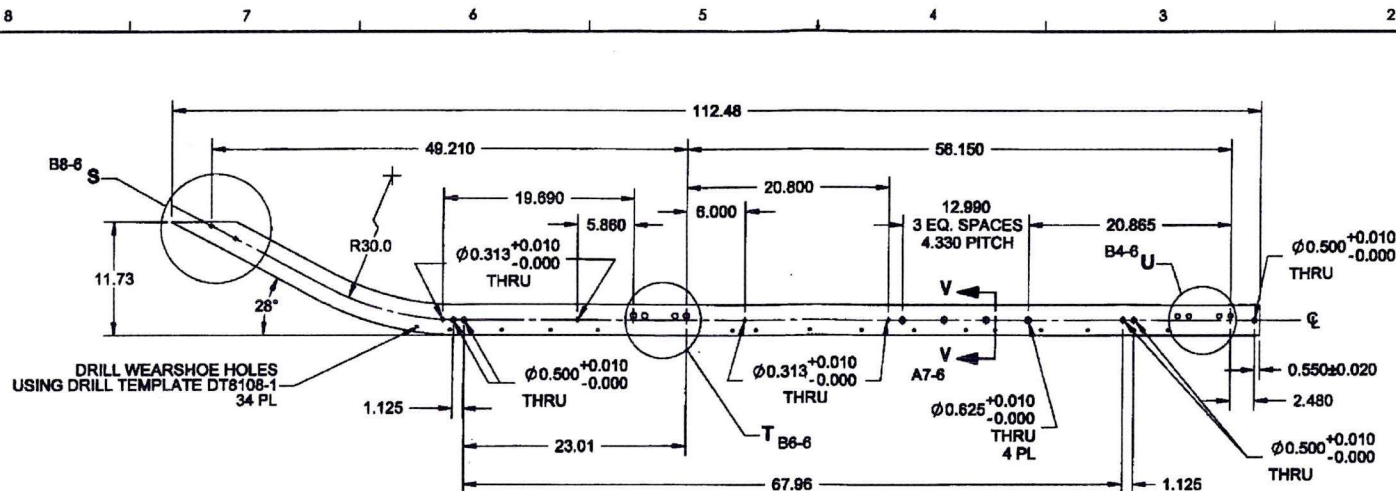
SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

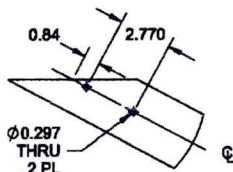
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
2013-08-13

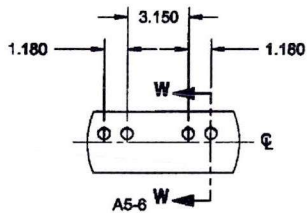


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

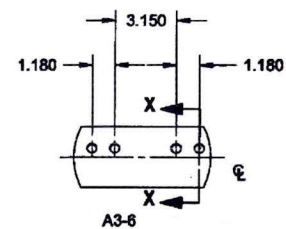
D2750-3 LH SKIDTUBE



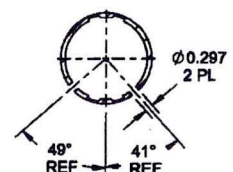
DETAIL S
SCALE 2X



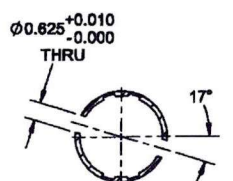
DETAIL T
SCALE 2X



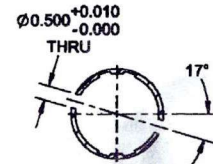
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



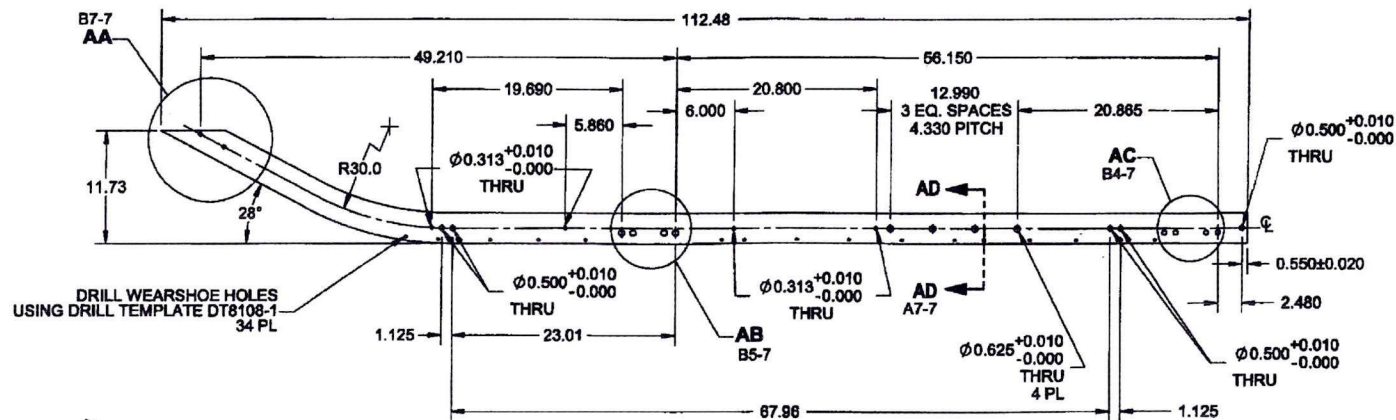
SECTION W-W
SCALE 3X, 4 PL



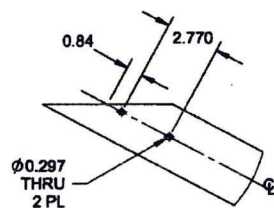
SECTION X-X
SCALE 3X, 4 PL

RELEASED
2013-08-13

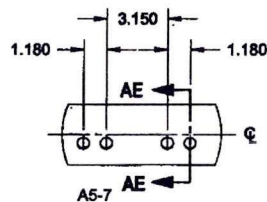
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 6 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRESENTED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER THAN THE PURPOSE FOR WHICH IT WAS WRITTEN OR FOR WHICH IT WAS DESIGNED.	



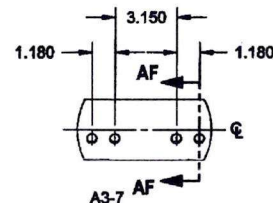
D2750-4 RH SKIDTUBE



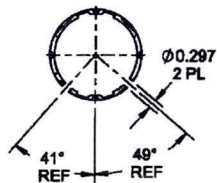
DETAIL AA
SCALE 2X



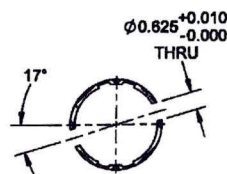
DETAIL AB
SCALE 2X



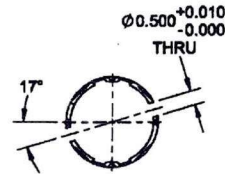
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



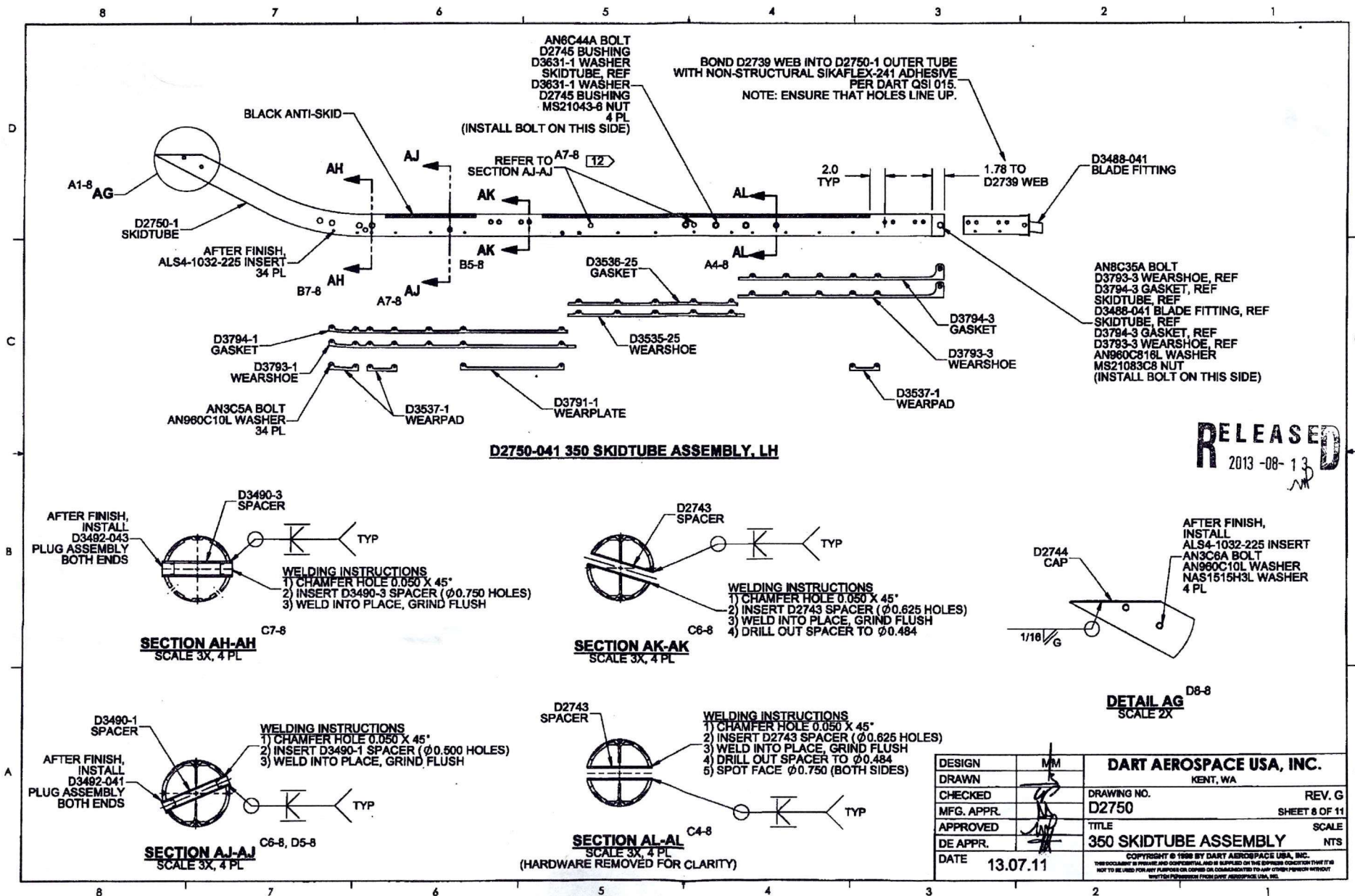
SECTION AE-AE
SCALE 3X, 4 PL

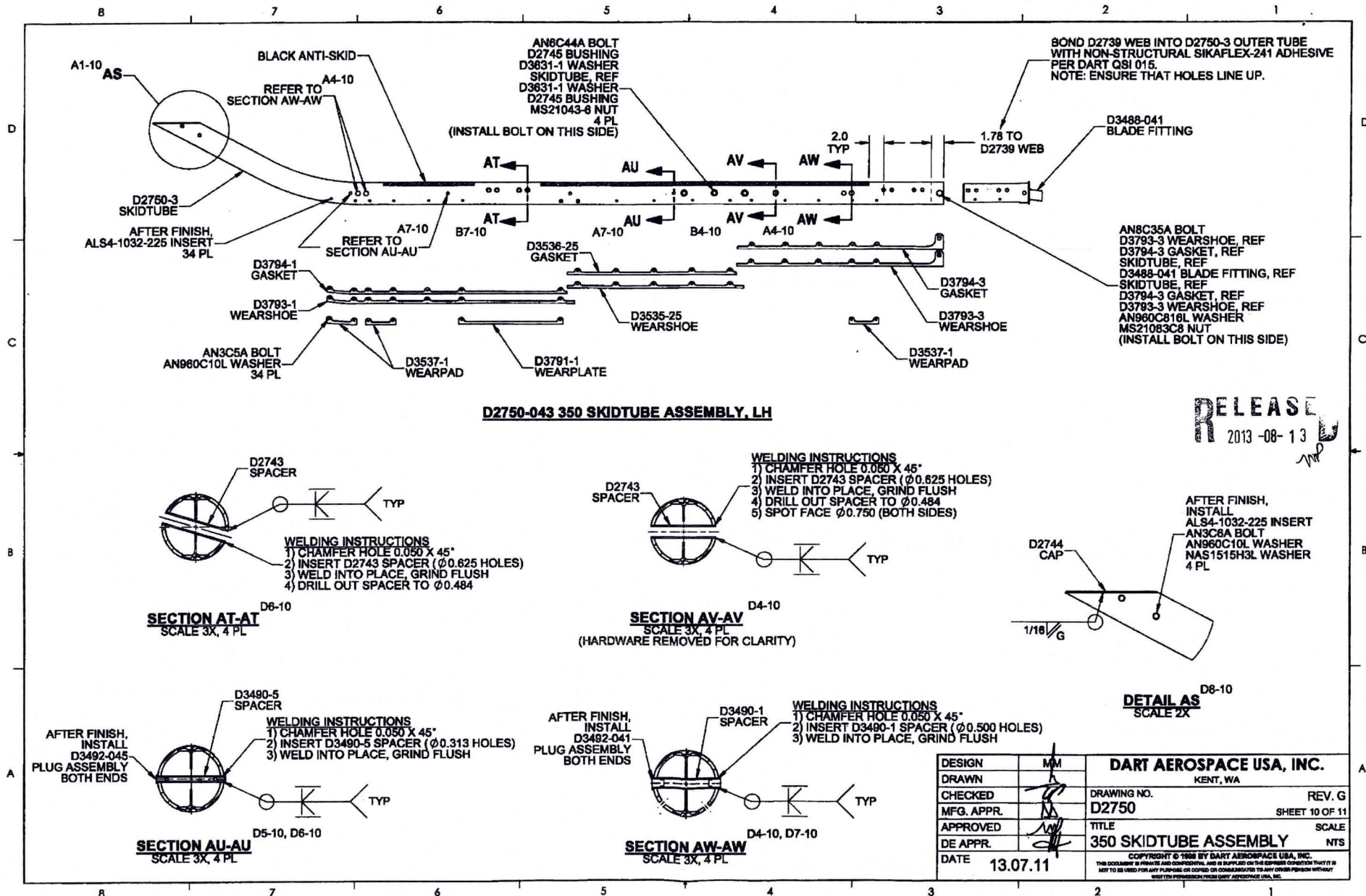


SECTION AF-AF
SCALE 3X, 4 PL

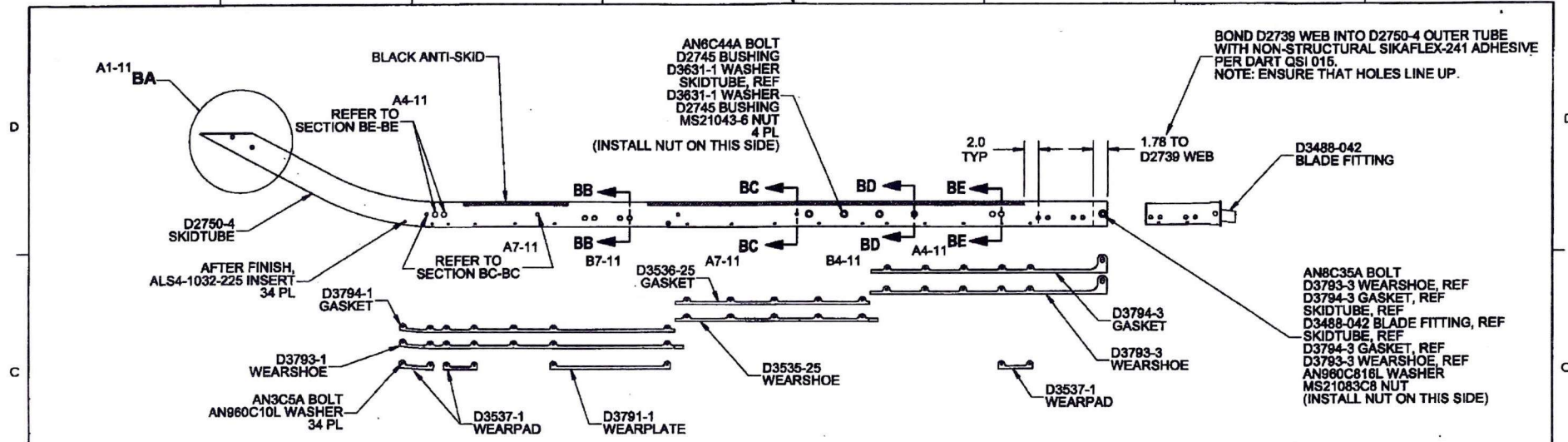
RELEASED
2013-08-13

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D2750	REV. G
MFG. APPR.		SHEET 7 OF 11	
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

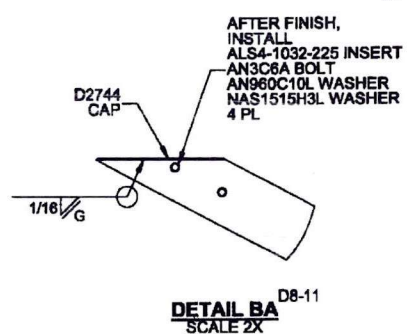
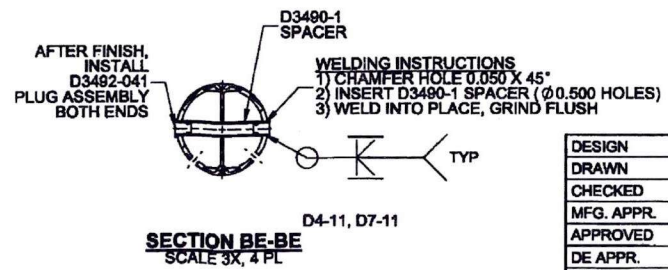
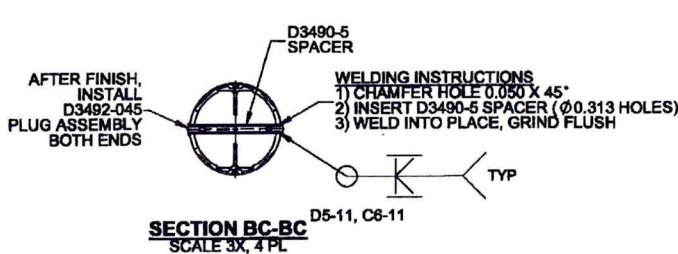
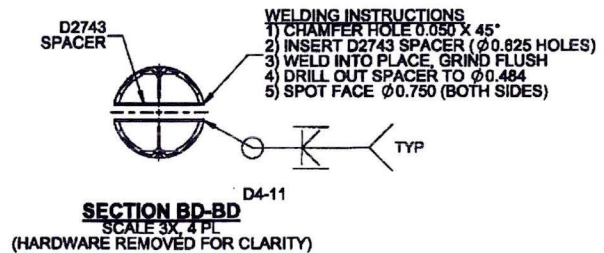
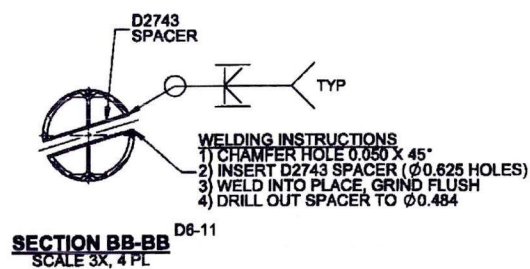




8 7 6 5 4 3 2 1



D2750-044 350 SKIDTUBE ASSEMBLY, RH



DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 11 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1999 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRESENTLY AND CONFIDENTIAL AND IS SUPPLIED BY THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
2013-08-13



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041713**

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO041713
PO Date: 11/13/18
Due Date: 11/16/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	184225	D350-636-011	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____	Firmed	-	11/16/18	1 pcs	0 pcs	1 pcs	\$325.00/pcs	\$325.00
2	183650	D135-751-011	1- Apply Primer as per QSI 005 4.2.1.3.3 and dwg A/R Primer Batch: _____ 2- Paint two coats of White paint as per QSI 005 4.2 and dwg A/R Paint Batch: _____	Firmed	-	11/16/18	1 pcs	0 pcs	1 pcs	\$325.00/pcs	\$325.00
3	182678	D350-636-016	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____	Firmed	-	11/16/18	1 pcs	0 pcs	1 pcs	\$325.00/pcs	\$325.00
4	185412	D350-636-013	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____	Firmed	-	11/16/18	1 pcs	0 pcs	1 pcs	\$325.00/pcs	\$325.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
PO041713

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	184892	D350-636-015	1- PRIME AS PER DWG AND QSI 005 4.2.1.3.3 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____	Firmed	-	11/16/18	1 pcs	0 pcs	1 pcs	\$325.00/pcs	\$325.00
Grand Total:											\$1,625.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/14/18 9:19 AM dart.tsimiklis.chrisoula